

Work Order ID 111619

January-15-14 2:02:24 PM

111619

Page 1

Item ID: D3144-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 1/15/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/29/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1/15/15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3144	Rev C								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT AS PER DWG D3144								
2024.032	DWG REV: <u>C</u>								
	PROG REV: <u>C</u>								
	DEBURR								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(4) 2/12 14/10/04

(4) 2/12 14/10/04

Work Order ID 111619

January-15-14 2:02:24 PM

111619

Page 2

Item ID: D3144-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 1/15/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/29/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(4)			38 9-89 14-10-6
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				H	14-10-6		DAS 34 9-89
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 m 127892 Memo START TIME: 11:30 FINISH TIME: 12:00	0.00 0.00				H	14-10-8		DAS 34 9-89

January-15-14 2:02:24 PM

Page 3

Quality Control

14-10-09

Picklist Print

January-15-14 2:02:28 PM

Page 1

Work Order ID: 111619

111619

Parent Item: D3144-1

D3144-1

Parent Item Name: Doubler

Start Date: 1/15/14

Required Date: 1/29/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B04.11.29Made by Laser CutKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No				sf	363.8000		1			
M2024T3S 032									**	<u>Dec 14/10/04</u>			
2024-T3 .032 sheet													

Location

Loc Qty

Loc Code

MAT022

363.8

121309

7

123574

14

124987

10

M127668

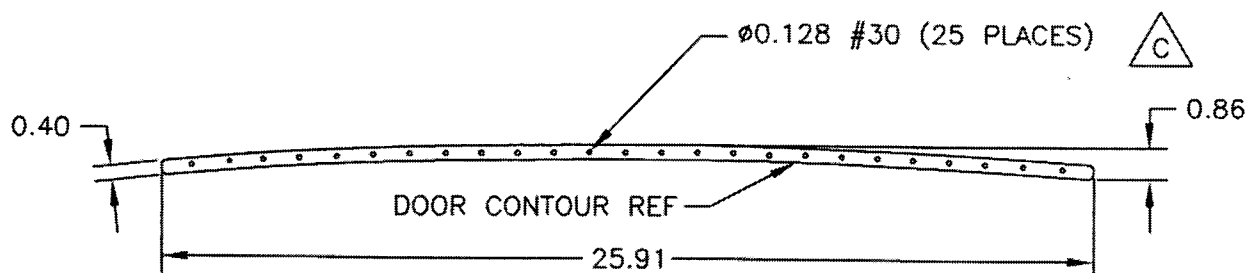
332.8

/30447

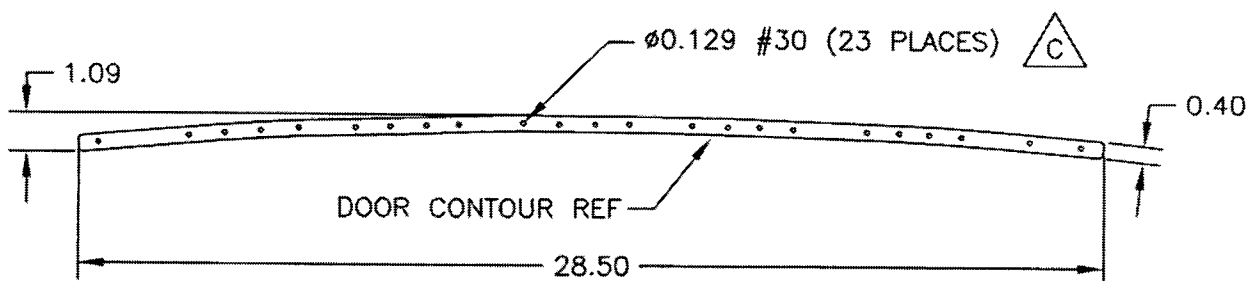
.993



RELEASED
05.11.14



D3144-1 DOUBLER (FOR D412-694-03)
REPLACES PREMIER P/N B30-23000-191



D3144-3 DOUBLER (FOR D412-694-01)
REPLACES PREMIER P/N B30-23000-193

Handwritten signature and date:
11/16/19

D3144-1/-3 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C1.DWG"

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.10.19	TITLE	DOUBLER	REV. C
A	02.04.22	NEW ISSUE		SHEET 1 OF 9
B	04.09.17	ADDED D3144-105/-107/-109/-111/-115/-121/-123; MODIFY D3144-1		SCALE
C	05.10.19	ADD D3144-15; Ø0.129 WAS Ø0.098		1:5